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D4149-5

Job Sheet 186649



Part No: D4149-5

Job Qty: 20 ea

Part Name: Eyebolt Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: ~~Stock~~ *SCD*

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		12/3/18	0.00	0.00	Start Up Machining-2		
100	Doosan	20 pcs		12/3/18	0.33	5.36	Doosan		
120	QC	20 pcs		12/3/18	0.00	0.00	QC8		
150	Packaging	20 pcs		12/3/18	0.00	0.00	Packaging3-2		
160	QC21-SA	20 Ea		12/3/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - turn as per dwg and folio FA950

DAS
21
9-89
NOV 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	5 ft (25 ea) <i>8.1 ft - 27 ea</i>	90-Start up Operation	<i>5123402</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R1.000	5	24	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Stud	0.250Inches + 0.003 - 0.000	0.253 0.250	Diameter	<i>.2505</i>
2	Eyebolt Stud	1.380Inches ± 0.030	1.410 1.350		<i>1.381</i>
3	Eyebolt Stud	0.400Inches + 0.000 - 0.010	0.400 0.390		<i>.397</i>
4	Eyebolt Stud	0.700Inches + 0.010 - 0.000	0.710 0.700		<i>.706</i>
5	Eyebolt Stud	0.030Inches ± 0.010	0.040 0.020	Radius	<i>R132</i>
6	Eyebolt Stud	0.375Inches + 0.000 - 0.020	0.375 0.355	Diameter	<i>.365</i>
7	Eyebolt Stud	0.700Inches	0.700	Diameter	<i>.695</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

		+ 0.000	0.690	
		- 0.010		
8	Eyebolt Stud	0.200Inches ± 0.010	0.210 0.190	.190
9	Eyebolt Stud	1.500Inches ± 0.010	1.510 1.490	1.4985
10	Eyebolt Stud	0.060Inches ± 0.030	0.090 0.030	Radius R 1/16
11	Eyebolt Stud	2.880Inches ± 0.030	2.910 2.850	2.88
12	Eyebolt Stud	0.310Inches ± 0.010	0.320 0.300	0.300 0.3135
13	Eyebolt Stud	0.750Inches + 0.003 - 0.000	0.753 0.750	.752
14	Eyebolt Stud	0.750Inches ± 0.030	0.780 0.720	.750
15	Eyebolt Stud	0.735Inches ± 0.010	0.745 0.725	.740

Plex 11/19/18 2:33 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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www.dartaerospace.com



Container No: S130119



Part: D4149 - 5

Job No: 186649

Serial No/Batch: S130119

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/21/18

FAULT CATEGORY

ure	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
e/Defect	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
mplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
mplete/Unclear	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence